	THE STREET PROPERTY OF THE STREET									
Work Order I. Monday, March 10, 2			*112	4534*		A CA		DA I		Page 1
Item ID: D35	80-1		Accept	*N900	040	100	\ }*	Setup Sta	art *N	Q1*
Revision ID:				1 4.70 70 7	·		•	C4		• • • • • • • • • • • • • • • • • • •
Item Name: Joggi	le Bracket						•	St	տ *//	S2*
Start Date: 3/10	/2014 Start Qty: 20.00	*20*		Cust Item l	ID:					
Required Date: 3/12	/2014 Req'd Qty: 20.00	*20*		Customer:						
Reference:		7()								
Approvals: Pro	ocess Plan:	Date: 14-3-1	Tooling:		ate:	_]	Run Sta	art *NI	D1 *
		• -	_					Ste	op qo	
QC		_ Date:	SPC (Y/N):	D	ate:				*N	R2*
Sequence ID/	Operation		Set Up/	Tool ID	Tool#	Plan	Accept		Reject	Insp.
Work Center ID	Description		Run Hours			Code	Qty	Qty	Number	Stamp
Draw Nbr	Revision Nbr									
D3580	Rev B									
100		, -	0.00				· -			
100	FLOW WATER JET						20	6		JM14-03-11
Waterjet	Memo		0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Rev:	r Dwg D3580								
304.050"	Prog Rev:_	B							•	
	2-Deburr if	necessary								
110	QC2- Inspect parts off m	nachine FAI/FAIB	0.00							
*11 0 *							. 2 ~	0		Jm14-03-11
QC	Memo		0.00				_ 20			<u> </u>
Quality Control										
						1				

120

QC8- Inspect parts - second check

120

Quality Control

Memo

 ∞

DQA:		_ Date:						_				TRACT
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Nork Order	update only	AEROSPACE
Q, r croseu.		Date.	· <u></u>					· · · · · · · · · · · · · · · · · · ·			, ,	1
Work Orde	er:				DISPOSITION				AGAINST [DEPARTMEN	IT/PROCESS	
				_	Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo				Scrap			Machining	Small Fab	P	rod. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/S	tore/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite		Supplier	
Root			İ	Desci	ription of work order update		nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design												
Doc/Data	_											
Equip/Tooling	_									1		
Handling/Pre	_											
Material	_											;
Operator	_	İ	Ì									
Offset/Setup	_											
Process												
Supplier												
Training												,
Transport] .				
Unapproved												
						FAI	ULT CA	TEGORY				
Landir	ng Gear			_	General		1		_	_		
ļ	Bending			<u> </u>	Bend		•	Program	L		imensions	Pressure/Forced
		Not Conce	ntric		BOM/Route	<u> </u>	Grain		<u> </u>		er tolerance	Set-up
	Cracks	.		<u> </u>	Broken/Damage/Defect		Hardwa			Part Incor	F	Temperature/Cure
		ink/Ripple	e/Wave	<u> </u>	Burrs		1	ion Incomplete/Ur	·	Part Lost/	-	Weld
	Cuffs			<u> </u>	Contamination	L	4	tions Incomplete/l	Jnclear	Part Mov	_	Wrong Stock Pulled
	Crushing	-			Countersink	\vdash	•	gned/off center		Positione	_	¬
	Heat Tre				Cut Too Short	<u> </u>	Mislabe		L	Power Lo	ss/Surge [Other
		on Strip ir	Tube	<u> </u>	Drawing	\vdash	Misrea					
	Marks/0			\vdash	Drill Holes		Off-set			-		
		Sequence			Finish		4	Calibration				
	IWave/T	wist in Tu	be	- 1	Fit/Function	1	IOut of	Seauence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order II	D 114534
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114534

Page 2

Monday, March	10, 2014 8:2	24:06 AM											
Item ID: Revision ID:	D3580-1			Accept	*N900	040	100) *	Setup	Start	*N	S1*	
Item Name:	Joggle Bracke	t								Stop	*N!	S2*	
	3/10/2014	Start Qty: 20.00	*20*		Cust Item I	D:							
Required Date:	3/12/2014	Req'd Qty: 20.00	*20*		Customer:								
Reference: Approvals:	Process Pla	n:	Date:	Tooling:	Da	ate:	_]	Run	Start	*NI	R1*	
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*NI	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	1.
1.20 Small Fab		Small Fab		0.00		DAS		20		· 		14/03	10
Small Fab			dwg D3580 using 1/8" offs	et die		30 9-89							
140 *1 4 \^* QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00 14 3 1	1			<u>20</u>					
150 *150* Packaging Packaging		Identify as per dwg & Sto	St 035	0.00				_2:	.	4/3	1116	1	

DQA:			Date:											`	
04 (14)			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UF	PDATE				_	AEROSPACE
QA Closed:	t		Date:								W	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
					_	Rework			Skid-tube	Crosstube			Water Jet	٦	Engineering
Part N	lo.					Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	7	Quality
			-			Use-as-is		Therr	noforming	Finishing			re/Packaging	7	Other
NCR N	10					Suspected Unapproved			Large Fab	Composite			Supplier		
				1					,						
Root				_	Desci	ription of work order update		nitial	Acti			Sign &	_		
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	+	QC Inspector
Design	4														
Doc/Data															
Equip/Tooling						:	1								
Handling/Pre															
Material															
Operator									1						
Offset/Setup Process										3					
Supplier	\dashv														
Training															·
Transport	\neg														
Unapproved															
				L			FAI	ULT CA	TEGORY			Į.			
Landii	ng Gear					General									
	Ben	ding				Bend		Folio/F	Program			Outside Dim	ensions	\neg_{P}	ressure/Forced
	Cen	tre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	s	et-up
	Cra	cks				Broken/Damage/Defect		Hardwa	are			Part Incorred	ci [ַ⊤	emperature/Cure
	Crir	np/Kinl	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	v	Veld
:	Cuf	fs				Contamination		Instruct	tions Incomplete/U	Inclear		Part Moved		v	Vrong Stock Pulled
	Cru	shing				Countersink		Misali	gned/off center			Positioned V	Vrong	_	
	Hea	at Treat	t			Cut Too Short		Mislabe	eled		L	Power Loss/:	Surge	c	Other
			Strip in	Tube		Drawing		Misrea							
		rks/Cha				Drill Holes		Off-set							
	_	_	quence		<u> </u>	Finish	$ldsymbol{le}}}}}}}$	4	Calibration						
	Wa	ve/Twi	st in Tub	e	j	Fit/Function	1	Out of	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord Monday, March				*11	4534*			Page
Item ID: Revision ID:	D3580-1			Accept	*N900040100*	Setı	up Start	*NS1*
Item Name:	Joggle Bracke	et					Stop	*NS2*
Start Date:	3/10/2014	Start Qty: 20.00	*20*		Cust Item ID:			
Required Date	: 3/12/2014	Req'd Qty: 20.00	*20*		Customer:			
Reference:			,					
Approvals:	Process Pla	an:	Date:	Tooling:	Date:	Run	a Start	*NR1*
	QC:		Date:	SPC (Y/N):	Date:		Stop	*NR2*
Sequence ID/		Operation		Set Up/	Tool ID Tool # Plan Acc	cept I	Reject	Reject Insp.

Run Hours

0.00

0.00

Work Center ID

160

Quality Control

160

QC

Description

QC21- Final Inspection - Work Order Release

Memo

MCJ 14-03-12 MF 3-21

Qty

Qty

Code

Number Stamp

Page 3

DQA:		Date:	:					_					7	ART
		_			WORK ORDER NON	-CC	ONFO	RMANCE / U				. –	_	AEROSPACE
QA Closed:		Date	: 							Wc	ork Order up	date only		
Work Orde	er:				DISPOSITION				AGAINST	DEI	PARTMENT	PROCESS		
	-				Rework	1		Skid-tube	Crosstube			Water Jet	٦ Eı	ngineering
Part N	lo.				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	i	Quality
					Use-as-is	1		noforming	Finishing			e/Packaging	1	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite			Supplier	J	
Root				Desci	ription of work order update		Initial	Act	ion		Sign &		$\overline{}$	
Cause	Dat	e Step	Qty	0000	or non-conformance		ief Eng		ription		Date	Verification		QC Inspector
Design		-	1 201		or more communities	 ```	ner Eng	2000.	iption		Dute	Vermoution	+	Qe mspector
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material						ĺ								
Operator														
Offset/Setup														
Process			j											
Supplier														
Training									•					
Transport		İ	1											
Unapproved			<u> </u>											
					· - ····	FA	ULT CAT	TEGORY						
Landi	ng Gear				General	_	,		,		·		_	
	Bendi	-		_	Bend		•	Program		_	Outside Dim	⊢	_	ssure/Forced
		e Not Conce	entric		BOM/Route	<u> </u>	Grain				Over/Under	 	_Set-	·
	Crack				Broken/Damage/Defect	<u> </u>	Hardwa			$\overline{}$	Part Incorre			nperature/Cure
		/Kink/Rippl	e/Wave		Burrs		1 '	ion Incomplete/Ur	•	-	Part Lost/Mi	ssing	_ Wel	
	Cuffs			_	Contamination		4	tions Incomplete/l	Jnclear		Part Moved	L.	Wro	ong Stock Pulled
	Crush	-		\vdash	Countersink	<u></u>	-	gned/off center		_	Positioned V	_	_	
	Heat			<u> </u>	Cut Too Short	\vdash	Mislabe				Power Loss/	Surge	Oth	er
:		ction Strip in	n Tube	-	Drawing	\vdash	Misrea							
		s/Chatter		\vdash	Drill Holes	<u></u>	Off-set							
	——	ng Sequence		<u> </u>	Finish	\vdash	4	Calibration -						
	i IWave	/Twist in Tu	he	1	Fit/Function	1	IOut of 9	Seguence						

Picklist Print

Monday, March 10, 2014 8:24:05 AM

Work Order ID: 114534

114534

Parent Item:

D3580-1

D3580-1

Parent Item Name: Joggle Bracket

Start Date: 3/10/2014

Required Date: 3/12/2014

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev : A New Issue 07.06.25 EC

IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	587.5000	0.01	$\widehat{(1)}$		·	
M304S18	RGA								**			Ĵ	M14-03-1

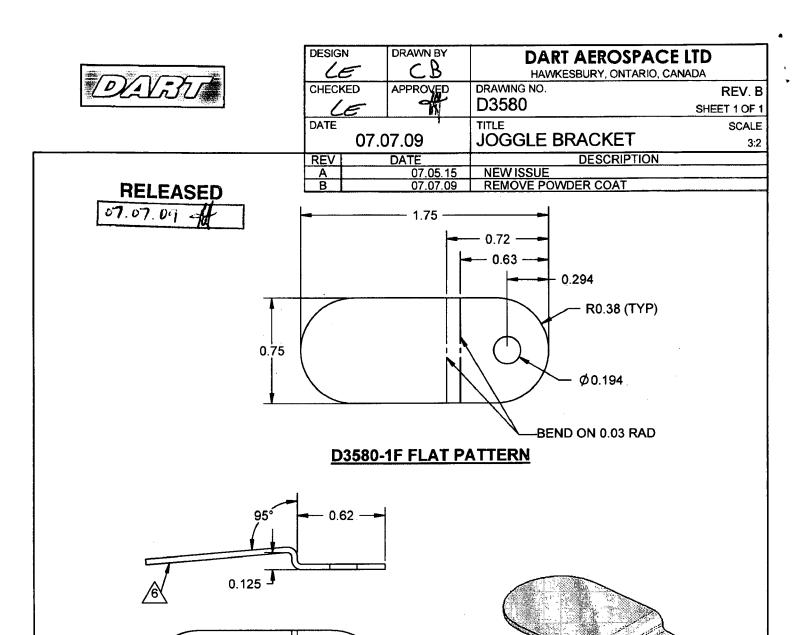
304/316 .050 Sheet

Location	Loc Qty	Loc Code	
MAT019	575.5		
117188	3		
117766	5		
120604	5		
122325	3		
123155	3		
124572	38		
M126647	39.75		
M128254	286.75		
M128435	192		128435
MAT020	12		
124029	2		
M126098	10		

Page 1

DQA:			Date:			WORK ORDER NON				DD 475			•		\T
QA Closed:			Date:			WORK ORDER NON	-CC	NFO	KIMANCE / UI		Wa	ork Order ug	odate only	AEROSPA	Î C E
	···					DISPOSITION						PARTMENT	<u>, , , , , , , , , , , , , , , , , , , </u>		
Work Orde	er:					2131 03111011	.			AGAINST		· AITHUEIT	, r KOCE33		
Part N	lo					Rework Scrap		·l	Skid-tube Machining	Crosstube Small Fab		Pro	Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	lo					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite		Rec/Sto	re/Packaging Supplier	Other	_ _
Root					Desci	iption of work order update	I	nitial	Act	ion		Sign &			
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	n QC Inspecto	or
Design		Ì													
Doc/Data	_														
Equip/Tooling							l								
Handling/Pre		l											1		
Material													·		
Operator		ŀ													
Offset/Setup															
Process						1									
Supplier															
Training									·						
Transport															
Unapproved															
							FAL	JLT CAT	TEGORY						
Landir	ng Gear					General				_		-	_		
	Ben	nding				Bend		Folio/P	rogram			Outside Dim	ensions	Pressure/Forced	
	Cer	ntre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up	
	Cra	cks				Broken/Damage/Defect		Hardwa	re			Part Incorred	cí _	Temperature/Cu	re
	Crir	mp/Kin	k/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Ur	nqualified		Part Lost/Mi	issing	Weld	
ļ	Cuf	fs				Contamination		Instruct	ions Incomplete/U	Jnclear		Part Moved	L	Wrong Stock Pull	led
	Cru	shing				Countersink		Misalig	ned/off center			Positioned V	Vrong _	_	
	Hea	at Treat	t			Cut Too Short		Mislabe	eled	Į		Power Loss/	Surge	Other	
	lnsı	pection	Strip in	Tube		Drawing		Misread	t						
	Ma	rks/Ch	atter			Drill Holes		Off-set							
	Tur	ning Se	equence			Finish		Out of 0	Calibration						
ĺ	l lwa	ve/Twi	st in Tub)e		Fit/Function		Out of	Sequence						

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D3580-1 JOGGLE BRACKET

- NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

- 1.68 (REF)

5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED

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DQA:		[Date:						_					7	TRAGE
QA Closed:		r	Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		14/	ork Ordon co	data anki. T		AEROSPACE
QA Closed.		L	Jate.			•	_				VVC	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
						Rework			Skid-tube	Crosstube			Water Jet	\neg	Engineering
Part N	10.					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.	7	Quality
					_	Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging	7	Other
NCR N	10					Suspected Unapproved			Large Fab	Composite			Supplier		
Root	i i				Desci	iption of work order update		Initial	Act	tion		Sign &		丁	
Cause	Di	ate S	Step	Qty		or non-conformance		nief Eng		ription		Date	Verification		QC Inspector
Design			-							•				十	· ,
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Equip/Tooling															
Handling/Pre															
Material															
Operator		ł													
Offset/Setup		1													
Process															
Supplier		ļ													
Training		l													
Transport															
Unapproved										.=					
							FA	ULT CAT	rEGORY						
Landii	ng Gear				_	General		,		ı			_	_	
	Ben	ding				Bend		Folio/P	rogram			Outside Dim	ensions	_ Р	ressure/Forced
	—	tre Not C	Concer	ntric	<u> </u>	BOM/Route		Grain				Over/Under	tolerance	s	Set-up
	Crac				<u> </u>	Broken/Damage/Defect		Hardwa	re			Part Incorred	: [_	┛	emperature/Cure
	Crin	p/Kink/	Ripple	/Wave		Burrs	<u>L</u>	Inspect	ion Incomplete/Ur	nqualified		Part Lost/Mi	ssing	\^	Veld
	Cuff					Contamination		-	ions Incomplete/l	Jnclear		Part Moved	<u>L</u>	\v	Vrong Stock Pulled
	_	shing				Countersink		Misalig	ned/off center			Positioned V	vrong _	_	
:	_	t Treat				Cut Too Short	L	Mislabe	eled			Power Loss/	Surge	<u> </u> c	Other
		ection S	-	Tube		Drawing	L	Misread	d						
	_	ks/Chatt				Drill Holes	<u></u>	Off-set							
į	_	ning Sequ				Finish		Out of 0	Calibration						
	Wav	/e/Twist	in Tub	e		Fit/Function		Out of 9	Sequence						

DART AEROSPACE LTD	Work Order: 114523	
Description: Joggle Bracket	Part Number: D3580-1	
Inspection Dwg: D3580 Rev: B	Page 1 of	1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	0.195	_		ν	Jamos
1.75	+/-0.030	1.753	-		V	
0.75	+/-0.030	1.753" 0-754"	_		V	
0.294	+/-0.010	0.293	-		V	
	77.74	,				

			\sim		
Measured by:	Jm	Audited by:	311	Prototype Approval:	N/A
Date:	14-03-11	Date:	14/3/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.10.30	New Issue	KJ/EC/DD	<i>X</i>

DQA:	Date:														
						WORK ORDER NON	-CO	ONFO	RMANCE / U				_		AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only		
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
	-				_	Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap	├			Small Fab		Prod. Eng. Coor.			Quality
	•				_	Use-as-is	1	Thern	noforming	Finishing		Rec/Store/Packaging			Other
NCR N	lo.		**			Suspected Unapproved]	Large Fab Comp		Composite		Supplier			
Post					Docc	rintion of work order undate	إ	nitial	Ι Δ.	ction		Sign 9		_	<u>- ·</u>
Root Cause		Date	Step	Qty	Desci	ription of work order update or non-conformance	1	Initial iief Eng		cription		Sign & Date	Verification	,	OC Inchestor
	\dashv	Date	Step	Qty	*	or non-comormance		Her Eng	Desc	inplion	\dashv	Date	vernication	<u>'</u>	QC Inspector
Design Doc/Data	\dashv	•							1						
Equip/Tooling	\dashv														
Handling/Pre	ᅥ													İ	
Material	\exists		1												
Operator	_						١								
Offset/Setup	\neg														
Process											ļ				
Supplier									1						
Training										•					
Transport									:						
Unapproved															
							FA	ULT CA	TEGORY			Ť			<u> </u>
Landir	ng G	iear				General		•					_		•
	Bending				<u> </u>	Bend		4	Program			Outside Dim	⊢		Pressure/Forced
]]	Centre Not Concentric			ntric		BOM/Route	<u>_</u>	Grain				Over/Under tolerance			Set-up
	Cracks					Broken/Damage/Defect	Hard		ırdware			Part Incorrect			Temperature/Cure
	Crimp/Kink/Ripple/Wave			:/Wave	<u> </u>	Burrs		1	on Incomplete/Unqualified			Part Lost/Missing			Weld
	Cuffs					Contamination	\vdash	4		ons Incomplete/Unclear		-			Wrong Stock Pulled
	Crushing					Countersink	<u> </u>	1 '	-	ned/off center		Positioned Wrong			1
	Heat Treat				<u> </u>	Cut Too Short	<u> </u>	Mislabe				Power Loss/	Surge		Other
	Inspection Strip in Tube			Tube	\vdash	Drawing	\vdash	4	Misread			***		_	
	Marks/Chatter				<u> </u>	Drill Holes	\vdash	Off-set			,			_	
	Turning Sequence					Finish	<u></u>	1	Calibration						
	Wave/Twist in Tube			oe		Fit/Function	1	Out of :	Sequence						